

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Currently Amended) A method of producing a structural beam with a web and openings located in the web, which comprises the steps of:

taking at least one initial universal beam;

determining a desired depth of a structural beam to be formed from the at least one initial universal beam and a width of material to be removed from the at least one initial universal beam to achieve the desired depth of the structural beam;

making a first cut generally longitudinally along the web of the or each initial universal beam on a first path, the web being generally rectangular in shape and having a first narrow edge and a second narrow edge opposite the first narrow edge, wherein the first cut extends from the first narrow edge to the second narrow edge;

making a second cut generally longitudinally along the web of the or each initial universal beam on a second path differing from the first path of the first cut to form cut halves, wherein the second cut extends from the first narrow edge to the second narrow edge, wherein the first and the second cuts are spaced apart from each other and do not intersect at any point thereby defining [[a]] the width of the material therebetween, the material extending from the first narrow edge to the second narrow edge;

separating the cut halves of the or each initial universal beam;

removing material between the first and second cut; and

welding the halves together to produce [[a]] the structural beam of [[a]] the desired depth,  
~~wherein the desired depth is variable at a time of manufacture by making the first and second cuts to achieve the width of the material corresponding to the desired depth.~~

2. (Previously Presented) A method according to claim 1, wherein the desired depth of the structural beam is less than that of the or each initial universal beam from which it is produced.

3. (Previously Presented) A method according to claim 1, wherein the first and second cuts along the web can be such that any shape of openings can be obtained.

4. (Previously Presented) A method according to claim 1, wherein the first and second cuts along the web can be such that any position of openings can be obtained.

5. (Previously Presented) A method according to claim 1, wherein the cut halves of the or each initial universal beams are separated and moved longitudinally relative to one another before being welded together.

6. (Previously Presented) A method according to claim 1, wherein the two halves of the or each initial universal beam are not moved longitudinally relative to one another before welding.

7. (Previously Presented) A method according to claim 1, wherein two or more universal beams are cut and separated into halves and the halves from different cut universal beams are used to produce the structural beam.

8. (Previously Presented) A structural beam prepared by the method of claim 1.

9. (Previously Presented) A structural beam according to claim 8, wherein the desired depth of the structural beam is less than that of the or each initial universal beam from which it is produced.